

06/29/2007

Dart Aerospace Ltd.












Monday, 3/26/2007 3:00:11 PM
Kim Johnston

Process Sheet

split 2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 5-MAN SHOULDER HARNESS KIT
Job Number : 31453	
Estimate Number : 10409	
P.O. Number : N/A	Part Number : D412702033
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : DSI 9312 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 27935	Material : N/A
Written By : <u> </u>	Due Date : 4/6/2007 Qty: <u>6</u> Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: A 05.11.03 New issue KJ/EC	
Est Rev: B 06-04-03 Remove Comments, Rev B JLM	
est rev C 06.12.14 per ecn 871 EC	

Additional Product

Job Number:	
Seq. #	Machine Or Operation: Description :
1.0	DC DOCUMENT CONTROL
	  (11)
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-702-033CHG001	
2.0	PACKAGING 1 PACKAGING RESOURCE #1
	 
Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D31961 Bar
	 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 11.0000 Each(s) Bar Batch: <u>B31273</u> (4x) 2x B 30146 ✓	
4.0	D3446041 Harness Assembly
	 
Comment: Qty.: 5.0000 Each(s)/Unit Total : 55.0000 Each(s) Harness Assembly Batch: <u>B30130</u> (30x) ✓	
5.0	D32681 Placard
	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s) Placard Batch: <u>B31274</u> (10x) B31468 12 ✓	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: HA Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:00:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 5-MAN SHOULDER HARNESS KIT

Job Number: 31453

Part Number: D412702033

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

MS24694S152

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 22.0000 Each(s)

Screw

Batch: M101124 - ✓

7.0

MS24694S154

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 22.0000 Each(s)

SCREW

Batch: M103926 - ✓

07/04/04 SD

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 207104/04 (6) P 27/4/04 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-033

Location: B

07/04/04 SD (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



07/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9312	REV. B SHEET 1 OF 1
DATE 06.03.24		TITLE UH-1 HARNESS INSTALLATIONS	SCALE NTS
A	05.09.29	NEW ISSUE	
B	06.03.24	REFORMAT, ADD -S154 SCREWS	

DART SERVICE INSTRUCTION

REFERENCE: INSTALLATION INSTRUCTIONS IIN-D412-702 REV. B or C

The following kit is available to provide 4-point shoulder harnesses for passengers on UH-1 aircraft:

The Dart **D412-702-033** 5-Man Shoulder Harness Kit provides 4-point harnesses for the 5 fwd-facing seating positions in the UH-1 aircraft cabin. The harnesses for this kit are approved under TSO-C114. This kit should be installed as per the D412-702-023 kit in installation instructions IIN-D412-702 except that the existing tubes (p/n 205-070-709-1) for the fwd-facing seats should be used to secure the shoulder harnesses instead of the D3197-041 bars (and associated fittings, ref.).

When installing the D3196-1 Bar, it is acceptable to substitute the MS24694-S152 screws for the longer MS24694-S154 screws (or longer MS24694-Sxxx screws as required) to ensure the bar is properly secured.

For each of the two outermost passenger positions, it is acceptable to install all 4 shoulder straps onto the existing seat tubes (p/n 205-070-709-1), instead of installing one on the D3196-1 Bar as per IIN-D412-702. Thus, for cases where the centermost seating position has been removed (or not used), installation of the D3196-1 Bar is not required.

The parts list for the kits are as follows:

QTY -033	Part Number	Description
X	D412-702-033	Dart 5-Man Shoulder Harness Kit, 4-point, for UH-1 aircraft
1	D3196-1	Bar
5	D3446-041	Harness Assembly, 4 point
2	D3268-1	Placard
2	MS24694-S152	Screw
2	MS24694-S154	Screw (use either -S152, -S154, or longer screws as req'd)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31453

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